

Date: Thursday, 4/12/2007 8:22:17 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOOR ASSEMBLY	
Job Number	31659		Part Number	D3213041	
Estimate Number	10713		Drawing Number	D3213 REV A	
P.O. Number	N/A		Project Number	N/A	
This Issue	4/12/2007 S.O. No. N/A		Drawing Revision	A	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	4/19/2007	
Previous Run	31429		Qty:	10	
Written By			Um:	8"	
Checked & Approved By			Each		
Comment	Est Rev:A New Issue 05-11-17 17:27				

Additional Product

Job Number:



/

Seq. #:	Machine Or Operation:	Description :	
1.0	D31613	Hinge 15.0"	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)	
		Pick: Assembly Kit	
		Qty Part Number Description Batch	
	2 D3161-3	Hinge B31431x6 B28287x14	
			FF 07-04-19
2.0	D32131	Door Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		Pick: Assembly Kit	
		Qty Part Number Description Batch	
	1 D3213-1	Door B31432	
			FF 07-04-19
3.0	D32133	Door Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		Pick: Assembly Kit	
		Qty Part Number Description Batch	
	1 D3213-3	Door B31703	
			FF 07-04-19
4.0	MS20470AD44	Rivet, Universal Head	
		Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)	
		Pick: Assembly Kit	
		Qty Part Number Description Batch	
	24 MS20470AD4-4	Rivet N103446	
			FF 07-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:22:17 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31659

Part Number: D3213041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

FF 07-05-01

10

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8B 07/05/02

10

7.0 POWDER COATING

POWDER COATING



M102316

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

HD 07-05-02

10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.D 07/05/03

9.0 D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit



Qty Part Number Description Batch
1 D2137 Decal B31330 x 6mx, B31463 x 4mx -

10.0 D2419

Handle



✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 D2419 Handle B31424 x 6mx, B31336 x 4mx -

11.0 D2462

Neoprene Seal



Comment: Qty.: 2.4000 f(s)/Unit Total : 14.4000 f(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 D2462 Seal B29456 -

-MF 07-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOOR ASSEMBLY
Job Number: 31659		Part Number: D3213041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	D27281 	Dart Logo label small
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D2728-1 Decal <u>b24215</u> - ✓		
13.0	AN960JD6 	Washer
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 AN960JD6 Washer <u>m6085</u> - ✓		
14.0	MS20470AD46 	Rivet, Universal Head
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 MS20470AD4-6 Rivet <u>m103691</u> - ✓ MF 07-05-03		
15.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3213 MF 07-05-03		
16.0	QC5 	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP SB 07/05/04		
17.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>P</u> 7/14/04 (10)		
18.0	QC21 	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE 07/05/07		
Job Completion 		W 07/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

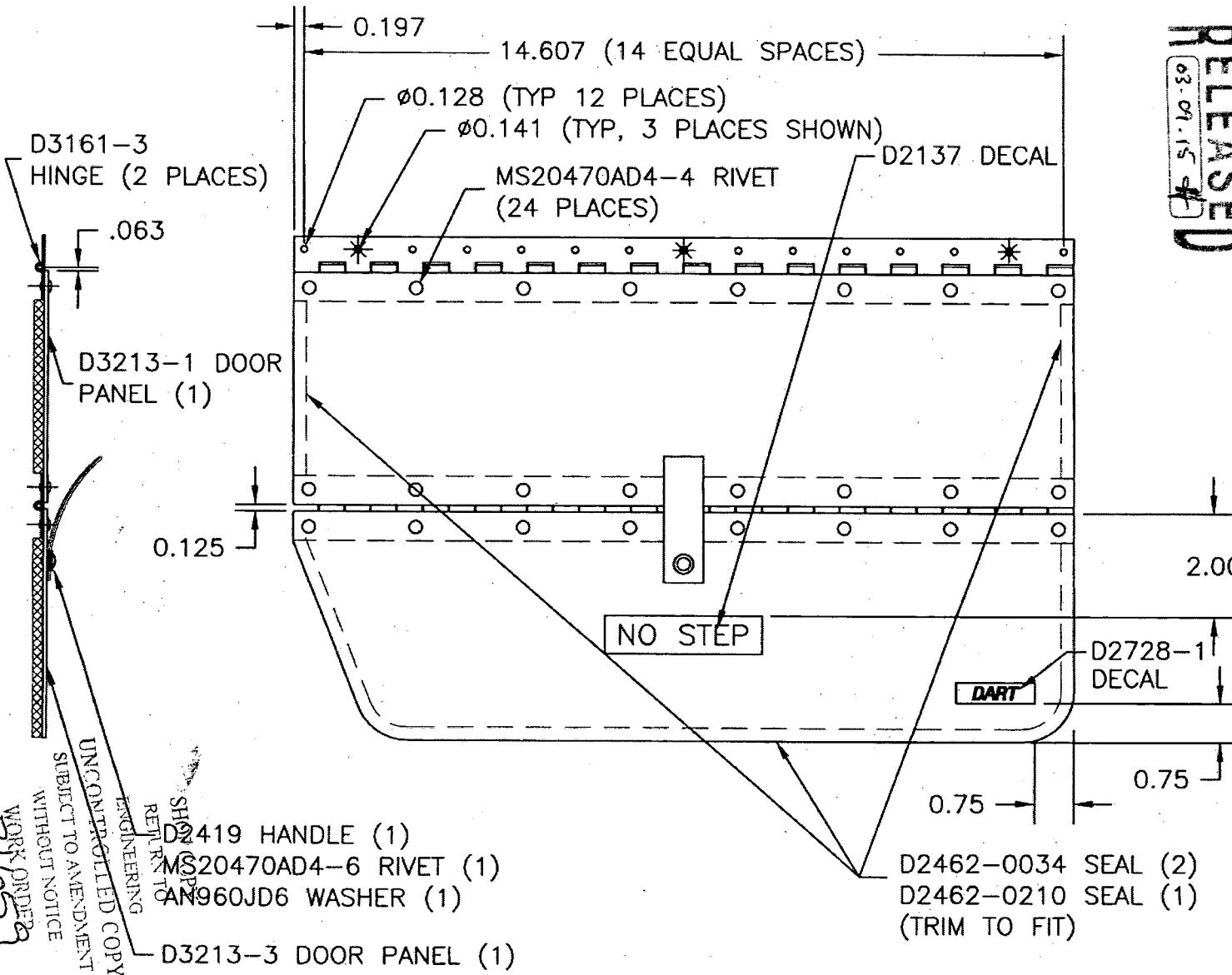
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY IN
SUN 04

DESIGN	A	DRAWN BY	CJ	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	03.09.03	DRAWING NO.	D3213	REV. A
TITLE	DOOR ASSEMBLY	SCALE	1 OF 2	
				1:3

RELEASED
03.09.03**D3213-041 DOOR ASSEMBLY**

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

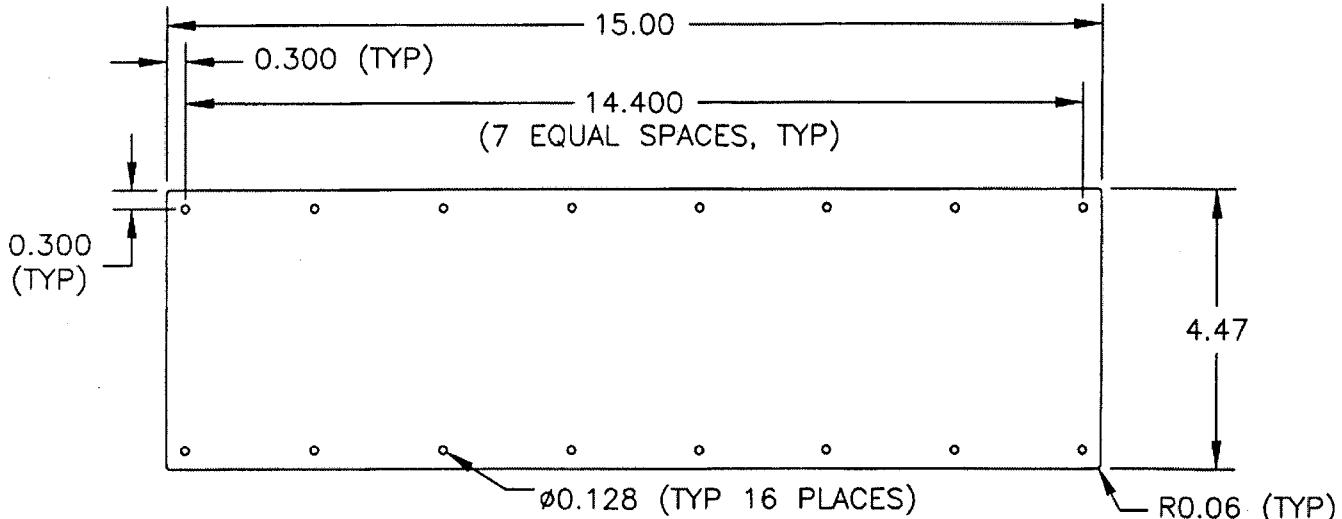
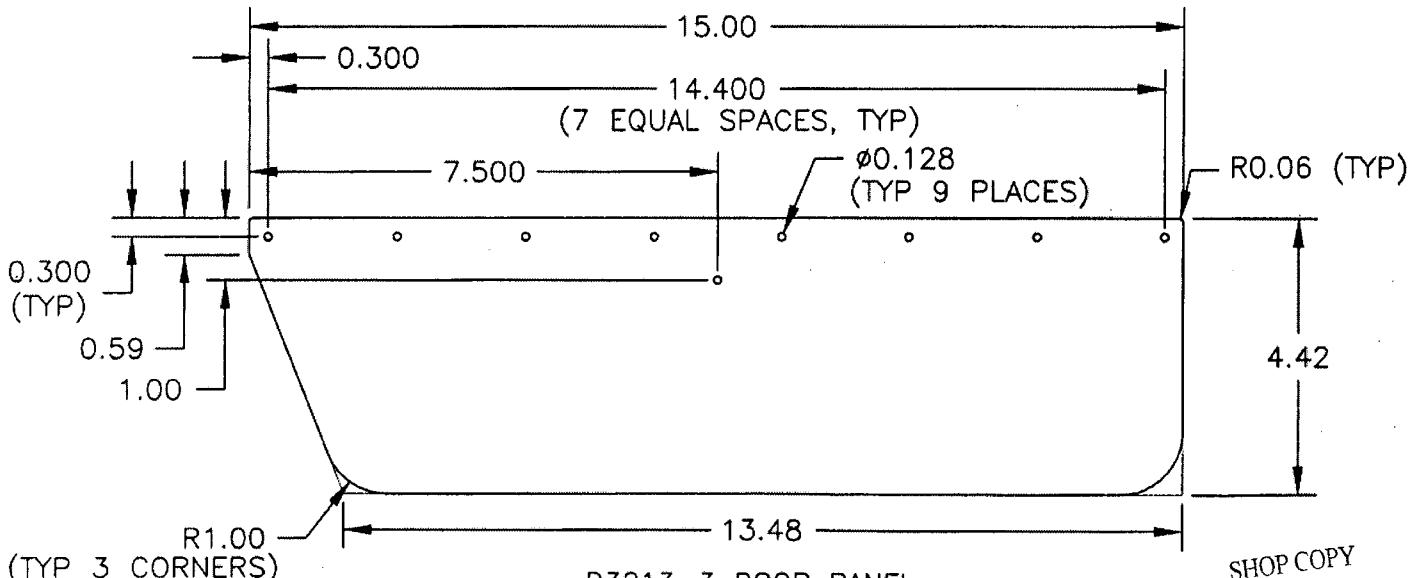
FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3

D3213-1 DOOR PANELD3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 SUBJECT TO AMENDMENT
 03.09.03
 WITHOUT NOTICE

 WORK ORDER
 NO. 31659